

# Work Order ID 57087

Saturday, March 20, 2010 10:23:20 AM



Page 1

Item ID: D4021-5

Accept

Revision ID:

Item Name: Blanking Plate

Start Date: 3/22/2010 Start Qty: 6.00

Required Date: 3/31/2010 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: MF

Date: 10-3-20

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4021

A

0.00



Waterjet

FLOW CNC Waterjet

Memo

Cut as per dwg D4021

Prog Rev: A

Dwg Rev: A

Deburr as required

0.00

10-3-23

8

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

10-3-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 57087**

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Item ID: D4021-5

Revision ID:

Item Name: Blanking Plate

Start Date: 3/22/2010 Start Qty: 6.00

Required Date: 3/31/2010 Req'd Qty: 6.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

5/10/03/23

(X8)

140



Packaging

Packaging

Identify as per dwg &amp; Stock Location: 109

0.00

Memo

0.00

PA 10/3/2 3 (8)

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/24

PA 10-3.23  
(8)



W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Saturday, March 20, 2010 10:23:19 AM

Page 1

Work Order ID: 57087

Parent Item: D4021-5

Parent Item Name: Blanking Plate

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC  
REV.A DD 10.02.22 verified by:EC

IPP Rev:B as per dwg

Start Date: 3/22/2010

Required Date: 3/31/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

140.0899

0.3928

16



304/316 Sheet 063



1310-3-23

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

140.0898737

106860

8.0295

111924

25.1689737

112442

29.8865

113295

77.0049

113295

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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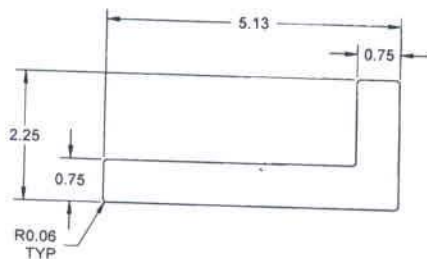
**NOTE:** Date & initial all entries



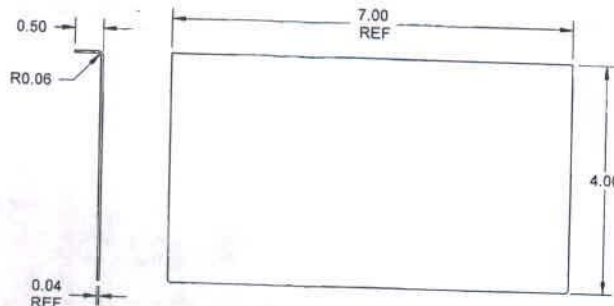




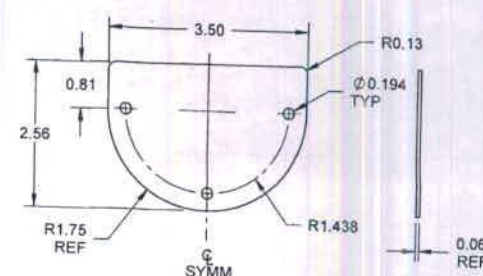




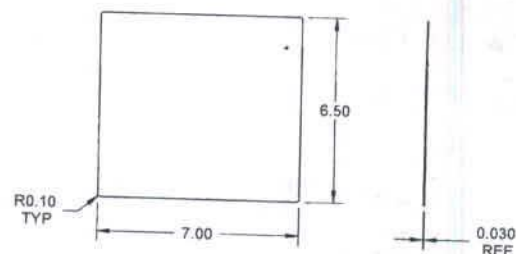
**D4021-1 HANDLE PLATE**



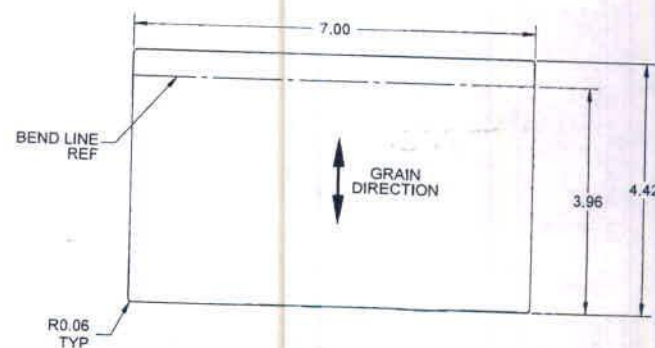
**D4021-3 DATA PLATE**  
MAKE FROM D4021-3F



**D4021-5 BLANKING PLATE**



**D4021-11 INSTRUCTIONS PLATE**



**D4021-3F DATA PLATE**  
FLAT PATTERN

**NOTES:**

1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA

-3F: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S20GA

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M303S16GA OR M304S16GA

-11: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S22GA

2) FINISH : NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT -1: 0.18 lbs

-3: 0.35 lbs

-5: 0.14 lbs

-11: 0.39 lbs

**RELEASED**  
2010-02-16  
MA

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWN	AJS		
CHECKED	JS	DRAWING NO.	SHEET 2 OF 3
MFG. APPR.	JS	D4021	
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	MISC PARTS - 350 BASKET	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMING OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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